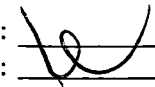


Date: Friday, 01/02/2008 8:40:27 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT DOUBLER
Job Number :	37132		
Estimate Number :	13151		
P.O. Number :		Part Number :	D37031
This Issue :	01/02/2008	Drawing Number :	D3703 U/R
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	/ /	Drawing Revision :	U/R
Previous Run :		Material :	
Written By :		Due Date :	08/02/2008
Checked & Approved By :		Qty:	2
Comment :	Est Rev:A 08-01-30 new issue DD verified by:		
	Type :	Um:	Each
	SMALL /MED FAB		

Additional Product

PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S063	6061-T6 .063 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.5915 sf(s)/Unit Total : 1.1829 sf(s)

6061T6 aluminium sheet .063" thick

(M6061T6S063)

Batch: 105225

LB 8-1-2

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3703

Dwg Rev: U/R

Prog Rev: U/R

LB 8-1-2

2- Deburr if necessary

LB 8-1-2

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

Bend as per Dwg D3703

LB 08-02-20

Date: Friday, 01/02/2008 8:40:27 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT DOUBLER

Job Number: 37132

Part Number: D37031

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

RF 8-02-20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

RF 08-02-20

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

RF 08-05-20

Job Completion



FOR ENGINEERING USE ONLY

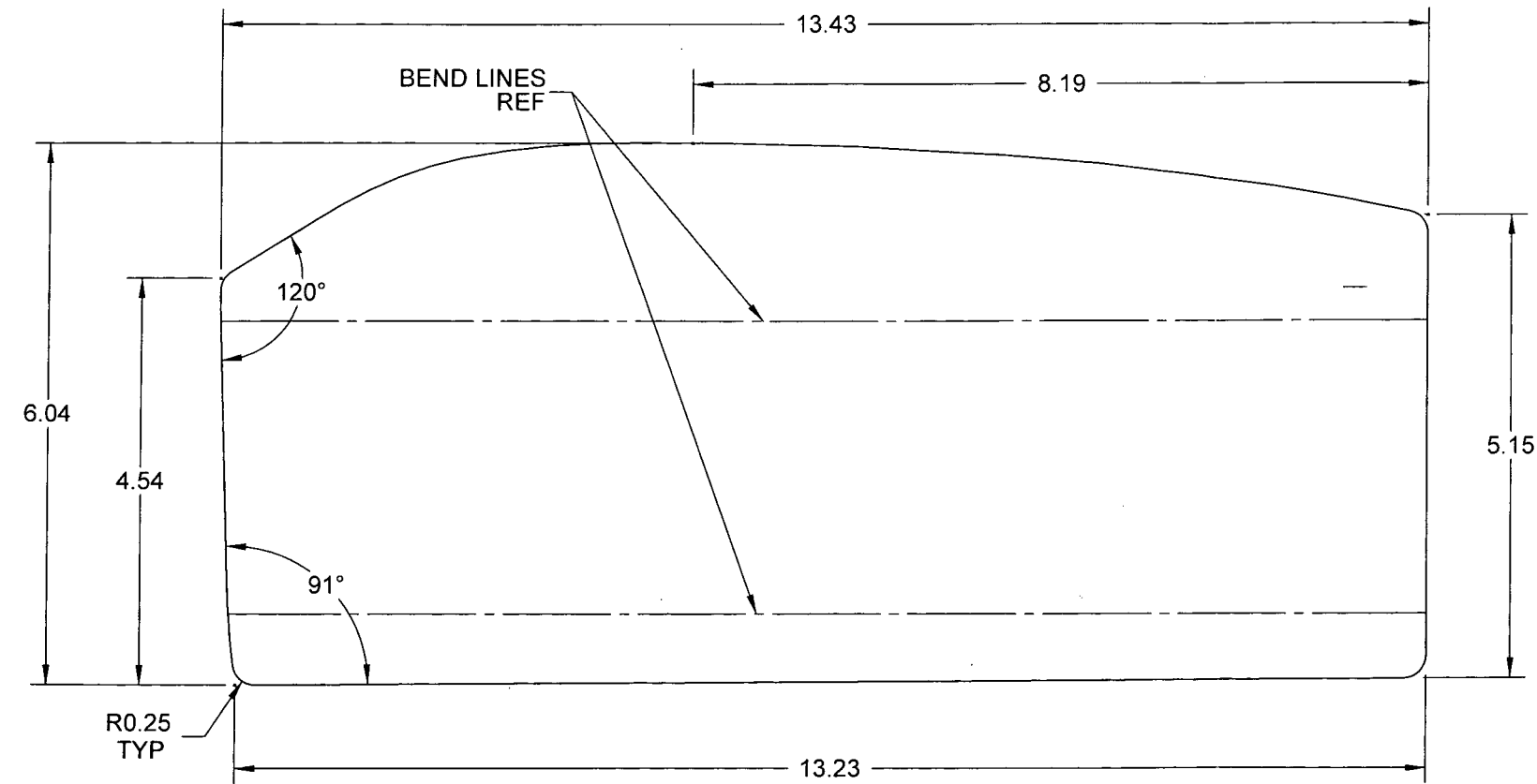
(Signature)

MF 08-05-16

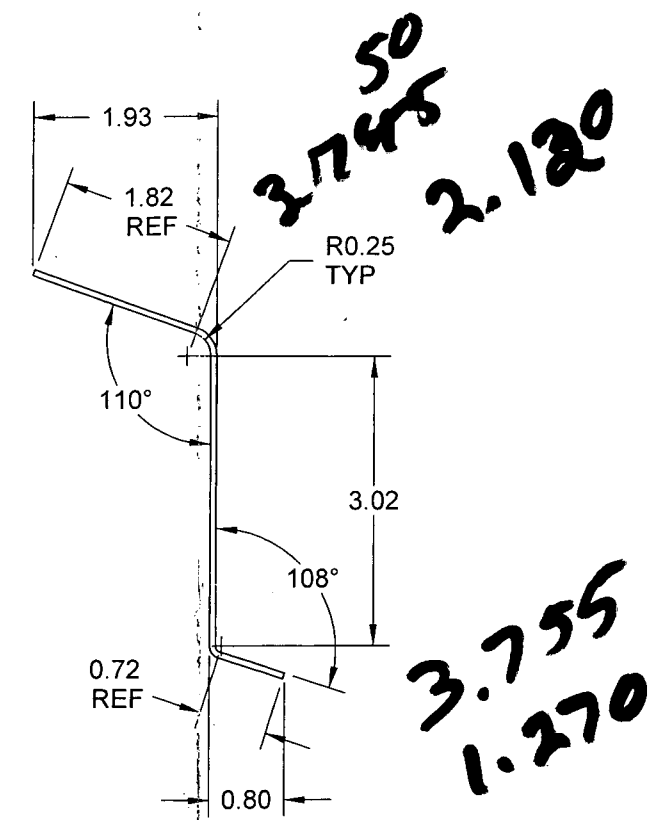
POSITIVE RECALL

EFFECTIVE 07-01 AUTH 24

RELEASED _____ DATE _____



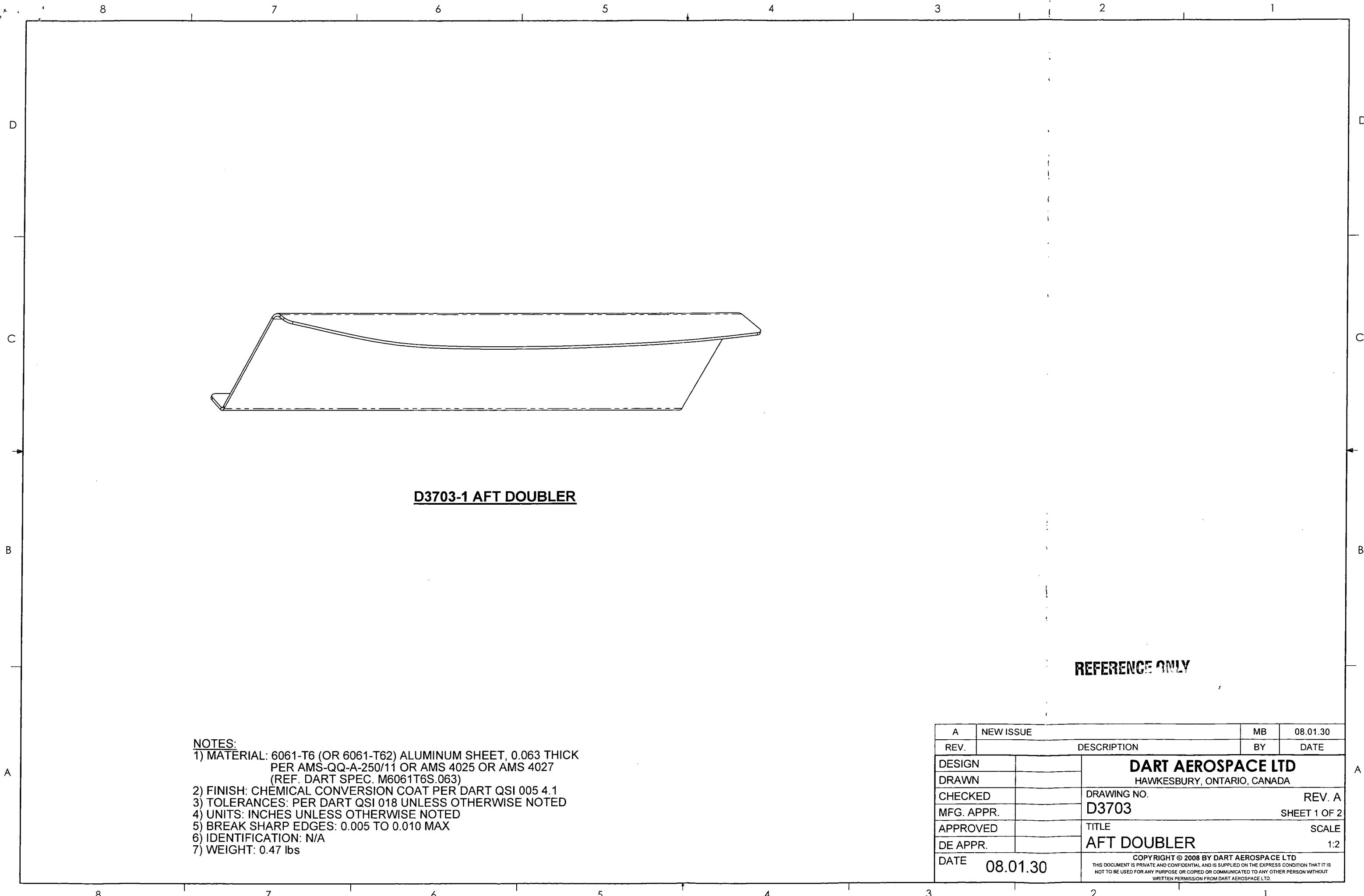
D3703-1F FLAT PATTERN



D3703-1 AFT DOUBLER
(MAKE FROM D3703-1F)

REFERENCE ONLY

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3703	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		AFT DOUBLER	1:2
DATE	08.01.30	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3703-1 AFT DOUBLER

REFERENCE ONLY

- NOTES:**
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.47 lbs

A	NEW ISSUE		MB	08.01.30
REV.	DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3703	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		AFT DOUBLER	1:2	
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